

Date: Monday, 27/10/2008 2:16:11 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X16")
Job Number : 42974	
Estimate Number : 12664	
P.O. Number :	Part Number : D206559011
This Issue : 27/10/2008 S.O. No. :	Drawing Number : D2435 REVE1
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 39220	Material :
Written By :	Due Date : 15/11/2008 Qty: 76 Um: Each
Checked & Approved By : <u>JLD 08-10-28</u>	
Comment : Est Rev:C 04-02-17 Blank size changed KJ/JLM Est Rev:D 07-01-02 Was K10007 JLM Est Rev:E 08-05-05 up a chg DD verified by:EC Est Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/01/12 @

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG006

S 09/01/12

2.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING

Program Batch Number

08-11-27

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 3.4083 sf(s)/Unit Total: 20.4498 sf(s)Material: Black UHMW 1"
(MUHMWB10)Batch: *109186*

B 8-12-2

(4)

4.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

Cut Blank as per File D2435

B 8-12-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

3-Deburr

J.L 09/01/10

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/01/10

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6660 f(s)/Unit Total : 9.9960 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion B42737

6664

50

10.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B42099

2 D2435(ref only) Bearpaw

9112

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D206559011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2438	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2438	Clamp	B41428

SP

12.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
8	D2529	Washer	B42408

SP

13.0	AN415A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-15A	Bolt	M109148

SP

14.0	AN417A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: M109061

SP

15.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
16	AN960JD416	Washer	M109249

9/1/12

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D206559011

Job Number:



Seq. #: Machine Or Operation: Description :

16.0 MS21042L4 Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M105054

M109282

SP

17.0 QS200M44S Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M107035

M109679

M106285

1 Paperwork package

9/1/12

SP

18.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/1/12

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: 11

Rev B

9/1/12

SP

20.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/13

Job Completion



mf 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42974
Description: bear paw 19X16		Part Number: D2435
Inspection Dwg: D2435	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	.063X45°	± .0010 ^{+ .030} _{- .010}	.070X45°	✓			
B	5.500	± .030	5.501	✓			
C	.200	± .030	.201	✓			
D	5.250	± .030	.250	✓			
E	.250	± .010	.245	✓			
F	.625	± .030	.625	✓			
G	.25X45°	± .030	.255X45°	✓			
H	.375	± .010	.375	✓			
I	19.00	± .030	19.00	✓			
J	.950	^{+ .030} _{- .010}	.954	✓			
K	Ø.260	^{+ .005} _{- 0}	.260	✓			
L	Ø.93	± .030	.924	✓			
M	.300	^{+ .030} _{- 0}	.315	✓			
N	.375	± .030	.378	✓			
O	7.375	± .0010 ^{+ .010}	✓ 7.374	✓			
P	4.250	± .030	4.250	✓			
Q	2.000	± .030	2.006	✓			
R	9.000	± .010	9.000	✓			
S	15.750	± .030	15.750	✓			

Measured by: JL	Audited by: J.F.	Prototype Approval:	N/A
Date: 09/01/10	Date: 09/01/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



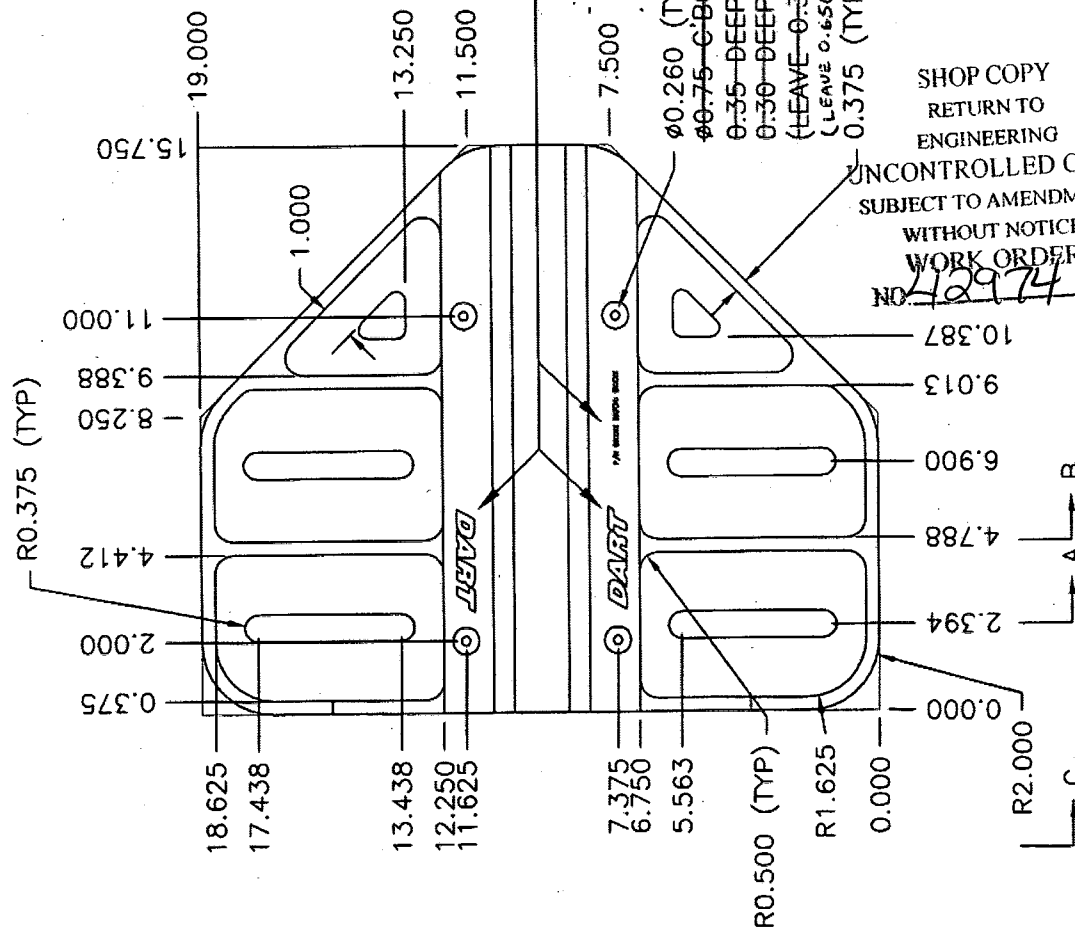
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143	

RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

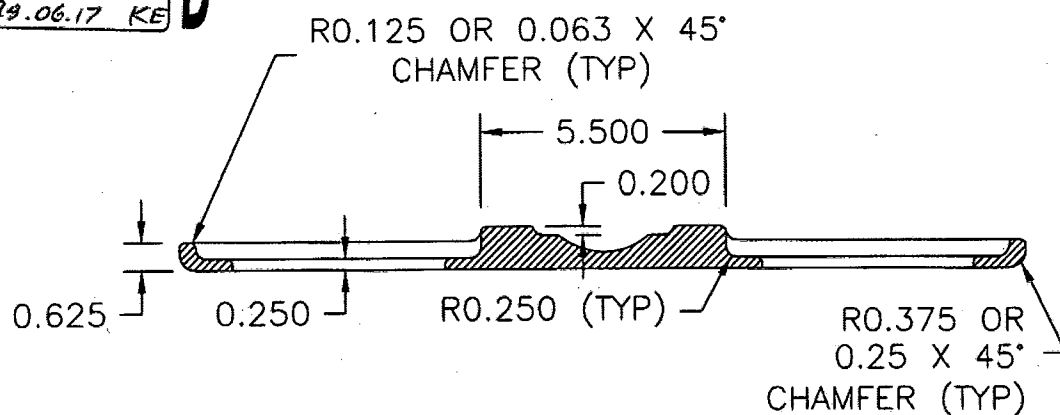
NO. 42974

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

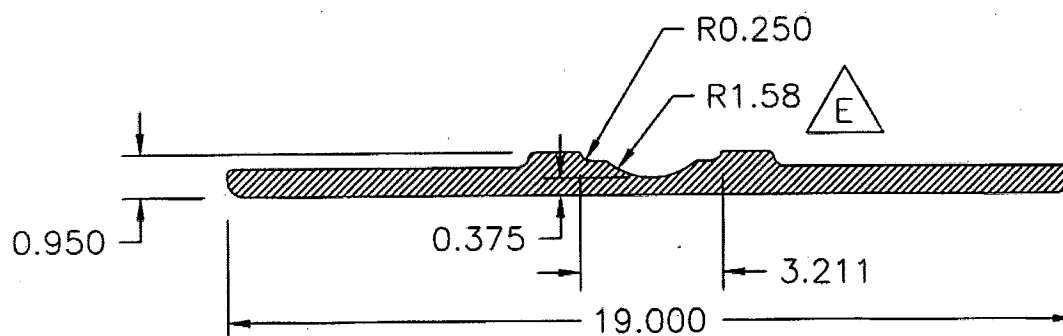


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

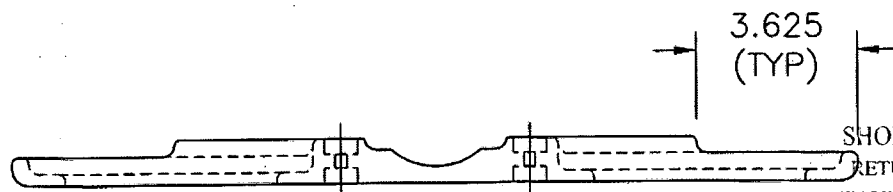
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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NO. 42974